

JULY



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 178811



Part No: D350-591-311

Job Qty: 5 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 7/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Large Fab-4		CPC
110	Large Fab	5 pcs	7/20/18	7/20/18	0.00	4.96	Large Fab 2		SLY
120	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC9		CPC
130	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC5		CPC
140	HandFinish	5 pcs	7/20/18	7/20/18	0.00	0.92	HandFinish1		SA 18-07-13
150	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC7-2		CPC
180	Large Fab	5 pcs	7/20/18	7/20/18	0.00	4.96	Large Fab 2		SLY
190	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC10		SLY
200	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC5		SLY
210	HandFinish	5 pcs	7/20/18	7/20/18	0.00	0.92	HandFinish1		SA 18-7-19
220	Powdercoat	5 pcs	7/20/18	7/20/18	0.00	1.45	Powdercoat1		DL 18-7-19
230	HandFinish	5 pcs	7/20/18	7/20/18	0.00	0.92	HandFinish3		DL 18-7-19
240	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC3		DL 18-07-23
250	Packaging	5 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		JUL 24 2018
260	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC4		JRB SP
270	Packaging	5 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		JRB SP
275	DC	5 pcs	7/20/18	7/20/18	0.00	0.00	DC		21 JUL 25 2018
280	QC21-FG	5 Ea	7/20/18	7/20/18	0.00	0.00	QC21		21 JUL 25 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138795 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 3:40 OVEN TEMPERATURE: 320° FINISH TIME: 3:10 M138439

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001



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Container No: S090375



Part: D350-591-311

Job No: 178811

Serial No/Batch: S090375

Revision:

Inspector:

Part No:

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (2 ea)	90-Start up Operation	5069554-3 5077589 → 7
D3219-1	Plate	10 Ea (2 ea)	90-Start up Operation	5070426
D3272-1	Step	5 Ea (1 ea)	90-Start up Operation	5085084
D3065-041	Step Leg Assembly	5 Ea (1 ea)	180-Large Fab	5092492
D3066-1	Spacer	10 Ea (2 ea)	180-Large Fab	5090186
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab	5079116
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	20 Ea (4 ea)	250-Packaging	
D2618	Bushing	10 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	10 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	10 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	5 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	256	0
	D3219-1	10	155	0
	D3272-1	5	10	0
180-Large Fab	D3065-041	5	32	0
	D3066-1	10	273	0
250-Packaging	MS20600-AD4W4	80	1,611	0
	AN3-35A	10	308	0
	AN4-13A	40	1,217	0
	AN5-36A	10	306	0
	D2230-3	20	20	0
	D2618	10	154	0
	D2856-400-720	10	60	0
	D3235-1	10	246	0
	D3278-041	5	46	0
	MS21042L3	10	1,903	0
	MS21042L4	40	2,976	0
	MS21042L5	10	659	0
	NAS1149D0363J	20	2,225	0
	NAS1149D0463J	80	5,149	0
	NAS1149D0563J	20	2,099	0

Part Specifications	
Specifications could not be found.	

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	5 pcs	7/20/18	7/20/18	0.00	4.96	Large Fab 2		
120	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC9		
130	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
140	HandFinish	5 pcs	7/20/18	7/20/18	0.00	0.92	HandFinish1		
150	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC7-2		
180	Large Fab	5 pcs	7/20/18	7/20/18	0.00	4.96	Large Fab 2		
190	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC10		
200	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
210	HandFinish	5 pcs	7/20/18	7/20/18	0.00	0.92	HandFinish1		
220	Powdercoat	5 pcs	7/20/18	7/20/18	0.00	1.45	Powdercoat1		
230	HandFinish	5 pcs	7/20/18	7/20/18	0.00	0.92	HandFinish3		
240	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC3		
250	Packaging	5 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		
260	QC	5 pcs	7/20/18	7/20/18	0.00	0.00	QC4		
270	Packaging	5 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		
275	DC	5 pcs	7/20/18	7/20/18	0.00	0.00	DC		
280	QC21-FG	5 Ea	7/20/18	7/20/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	10 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	5 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	5 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	10 Ea (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	20 Ea (4 ea)	250-Packaging	
D2618	Bushing	10 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	10 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	10 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	5 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	183	0
	D3219-1	10	73	0
	D3272-1	5	0	0
180-Large Fab	D3065-041	5	8	0
	D3066-1	10	258	0
	MS20600-AD4W4	80	3,044	0
250-Packaging	AN3-35A	10	380	10

Allocated Container Detail

Qty	Container No	Location	Init
2	S090716	st348	
8	S091084	st348	
AN4-13A	40	2,243	40

Allocated Container Detail

Qty	Container No	Location	Init
40	S091082	st344	
AN5-36A	10	324	10

Allocated Container Detail

Qty	Container No	Location	Init
10	S091075	st336	
D2230-3	20	247	20

Allocated Container Detail

Qty	Container No	Location	Init
20	S091184	st521	
D2618	10	511	10

Allocated Container Detail

Qty	Container No	Location	Init
2	S090791	st008	
8	S091094	st008	

D2856-400-720	10	74	10
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Allocated Container Detail

Qty	Container No	Location	Init
10	S091092	st418	_____

D3235-1	10	273	10
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Allocated Container Detail

Qty	Container No	Location	Init
10	S091095	st522	_____

D3278-041	5	42	5
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Allocated Container Detail

Qty	Container No	Location	Init
1	S091096	st522	_____
4	S076688	st522	_____

MS21042L3	10	1,920	10
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Allocated Container Detail

Qty	Container No	Location	Init
2	S090693	st303	_____
8	S091071	st303	_____

MS21042L4	40	3,914	40
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Allocated Container Detail

Qty	Container No	Location	Init
8	S090692	st303	_____
32	S090959	st303	_____

MS21042L5	10	870	10
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Allocated Container Detail

Qty	Container No	Location	Init
2	s090688	st303	_____
8	S090952	st303	_____

NAS1149D0363J	20	1,444	20
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Allocated Container Detail

Qty	Container No	Location	Init
4	s090691	st263	_____
16	S090947	st263	_____

NAS1149D0463J	80	7,036	80
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Allocated Container Detail

Qty	Container No	Location	Init
16	S090690	st263	_____
64	S090946	st263	_____

NAS1149D0563J	20	1,587	20
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Allocated Container Detail

Qty	Container No	Location	Init
4	s090689	st263	_____
16	S090945	st263	_____

Part Specifications	
Specifications could not be found.	



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004332	S090716	AN3-35A	Bolt	s067891	ST348	2
004332	S091084	AN3-35A	Bolt	S067891	ST348	8
004332	S091082	AN4-13A	Bolt	S067892	ST344	40
004332	S091075	AN5-36A	Bolt	s068656	ST336	10
004332	S091184	D2230-3	Mounting Lug	S085080	ST521	20
004332	S090791	D2618	Bushing	s082275	ST008	2
004332	S091094	D2618	Bushing	S082275	ST008	8
004332	S091092	D2856-400-720	Abrasion Strip 4" X 7.20"	S079659	ST418	10
004332	S053650	D3235-1	Mounting Lug	S053649	ST522	2
004332	S091095	D3235-1	Mounting Lug	s069956 X3	ST522	6
004332	S091096	D3278-041	Support Assembly	S083384	ST522	1
004332	S092782	D3278-041	Support Assembly	s092071 X5	ST522	4
004332	S090692	MS21042L4	Nut	s062378	ST303	8
004332	S090959	MS21042L4	Nut	S062378	ST303	32
004332	S090688	MS21042L5	Nut	s058178	ST303	2
004332	S090952	MS21042L5	Nut	s058178	ST303	8
004332	S090691	NAS1149D0363J	Washer	s015269	ST263	4
004332	S090947	NAS1149D0363J	Washer	S015269	ST263	16
004332	S090690	NAS1149D0463J	Washer	s062379	ST263	16
004332	S090946	NAS1149D0463J	Washer	s062379	ST263	64
004332	S090689	NAS1149D0563J	Washer	s068662	ST263	4
004332	S090945	NAS1149D0563J	Washer	s068662	ST263	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

MS21042 L3 Quantity 10 S078167

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hel-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Hel-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Hel-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Hel-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Hel-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Hel-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.